

Line  $CO$  will be the Perpendicular requir'd; because it is not more inclin'd towards the Part  $DA$ , than towards the Part  $EB$ .

#### Fourth PROBLEM.

Through the Point given, to draw a Parallel to the Line given.

Let  $A$ , fig. 76. be the Point given, through which is to be drawn a Parallel to the Line given  $CB$ , let the right Line  $AD$  be drawn cutting the right Line given  $CB$  in  $D$ ; and from the Point  $D$  be described the Arch  $AF$ , and from the Point  $A$ , at the same Interval, be described the other Arch  $DE$ , into which the Arch  $AF$  is to be transferred, viz. from  $D$  into  $G$ ; then the right Line  $AG$  will be the Parallel required; because the alternate Angles  $ADF$ , and  $DAG$  are equal.

#### Fifth PROBLEM.

Between two Lines given to find a *middle Proportional*.

Let  $BD$ ,  $DC$ , fig. 78. be the Lines given, placed in a direct Line, and form the right one  $BC$ , from whose middle Point  $E$  must be described the Semicircle  $ABC$ , then from the Point  $D$  will be drawn the Perpendicular  $DA$ , meeting with the Circumference in  $A$ ; I say that such Line is the middle Proportional between  $BD$ , and  $DC$ .

For the Lines  $BA$  and  $CA$  being drawn, the Angle  $BAC$  is formed in the Semicircle, and consequently is a right Angle; therefore the Perpendicular  $AD$ , being let to fall on the Base  $BC$  is the middle Proportional, between the Segments, or Lines given  $BD$ ,  $DC$ .

#### SCHOLIUM.

A middle Proportional is found *Geometrically* between two Lines given; but no geometrical Method has been found yet, whereby two, or several middle Proportionals between two given Lines could be found. It is true, that some mechanical Rules are given conducive to it, viz. by several Instruments contrived for that Purpose, which have been imagined by *Plato*, *Archytas*, and other Antients; but particularly by *Des Cartes*, whose Invention is far preferable to all others; in that it is not confined to only two, but may be applied to find as many middle Proportionals between two Lines given, as one pleases.

By finding two *Proportionals* between two Lines given, the famous Problem of *Delos* of the *Duplication of the Cube* is executed; and that my Pupils may have some Notion how it is done, it must be understood that a Square is made of any Quantity, viz. a Number, or a Line multiplied by itself, the Side or Root thereof is that same Quantity; then if the Square be multiplied by the same Root, there will arise a Cube, whose Side or Root is the same Quantity. For Example, if you multiply 2 by 2 it will produce the Square 4, whose Root is 2. Again, if the Square 4 be multiplied by the Root 2 it will produce the Cube 8, whose Root is the same Number 2. Likewise, if you carry 4 into 4 you'll produce the Square 16, which Square being multiplied by 4, will give the Cube 64.

But if there be four Quantities continually proportional, such as  $2 : 4 :: 8 : 16$ , the Cube of the first is to the Cube of the second, as the first is to the fourth; for 2 is to 16, as 8 the Cube of the said 2, is to 64. the Cube of the said 4. because as 2 is the eighth Part of the Number 16; so 8 is the eighth Part of the Number 64.

Therefore if two Lines were given, the last whereof was the *Dupla* of the first; and between those two, other two Proportionals should be found, so as for the fourth Proportional to become the *Dupla* of the first; it is manifest that the Cube, which would be form'd in the second Proportional, would be the *Dupla* of that form'd in the first; because the Cube of the first Line would be, with regard to the second, as the first Line to the fourth; but the first would be to the fourth as 1 to 2; therefore the first Cube would be to the second, as 1 to 2.

Therefore for the Duplication of the Altar of *Delos*, which was cubical, there should have been taken a Line

*duple* each of its Sides; and between the Side and that Line, two middle Proportionals should have been searched.

#### Sixth PROBLEM.

A Triangle given, to make a rectangular Parallelogram equal to it.

Let  $ABC$ , fig. 77. be the Triangle given, through whose Vertex  $A$ , must be drawn the right Line  $AG$ , parallel to the Base  $BC$ ; then the Base  $BC$  is to be divided into two equal Parts in the Point  $D$ , from which the Perpendicular  $DE$  is drawn as far as to the Parallel  $AG$ : Let  $EF$  be taken equal to the Side  $DC$ , and the Side  $CF$  be drawn, the Rectangle  $DF$  will be equal to the Triangle given.

#### Seventh PROBLEM.

A Parallelogram being given, to make a Square equal to it.

Let  $CDEF$ , fig. 79. be the Parallelogram given, between the Longitude thereof  $DC$ , and its Altitude  $CF$ , or  $Cf$ , the middle Proportional  $CA$  must be found; the Square  $CB$ , of that middle Proportional, will be equal to the given Rectangle.

#### Eighth PROBLEM.

To measure an horizontal Line, which can only be accessible by one of its Extremities.

Let it be the Line  $AB$ , fig. 89. which can only be accessible in the Point  $B$ , the Longitude of which Line is to be searched.

First, let a Perpendicular be drawn in the Point  $B$ , to that same Line  $AB$ , viz.  $BC$ , in this Manner: You must place the Center of the Instrument, viz. of the *Semicircle*, described fig. 90. in the Point  $B$ , and thro' the Holes of its immobile Dioptré  $dd$ , fig. 90, 91. look some fix'd Object, placed in the other Extremity of the Line, viz. a small Tree, or the Tower  $A$ , and move the Dioptré, or mobile Rule, till it departs from the Base, or immobile Rule, by the whole Square, or 90 Degrees: If through the Holes which are open in the *Pinnule* of the Dioptré, you look some Mark placed in  $C$ , you'll have the right Angle  $ABC$ .

Let the Instrument be transferred into  $C$ , so that its Center answers to the Point  $C$ , and the Holes of the immobile Dioptré  $dd$ , be directed on the Point  $B$ ; turn the moveable Dioptré without moving the Instrument, till the Sign  $A$  appears thro' the moveable *Pinnula*  $ee$ ; then you'll know the Quantity of the Angle  $ACB$  in the Limb  $ed$  of the Semicircle.

To measure the Line  $BC$ , you must draw on Paper the Line  $FE$ , fig. 90. divided into so many equal Parts, as there are Feet found in the Line  $BC$ , and let the Angle  $FEG$ , fig. 90. be equal to the Angle  $BCA$ , afterwards the Perpendicular  $FG$  must be drawn thro' the Point  $F$ , meeting with the Line  $EG$  in the Point  $G$ . If with the Scale you measure how many Parts there are in  $FG$  equal to the Parts of the Line  $FE$ : I say that there are as many Feet in  $AB$ .

*Demonstration.* The Triangle  $ABC$ , and  $GFI$ , are *Equi-angles*, by Construction; therefore as  $FD$  is to  $FG$ , so  $BC$  is to  $BA$ : So that as many aliquot Parts of the Line  $FE$ , are contained in  $FG$ ; so many similar aliquot Parts from the Line  $BC$  will be contained in  $BA$ .

#### Ninth PROBLEM.

To measure an accessible Altitude.

Make use, as in the preceding Problem, of the *Semicircle* so disposed, that its Diameter or Base be parallel to the Horizon; then rise or lower its mobile Dioptré, till through its *Pinnula* the Vertex  $A$ , fig. 91. be seen: Afterwards look downward through the same *Pinnula*, that you may have the Point  $C$ ; mark carefully the Angle  $AI$ , or  $EIC$  equal to it, to which the Angle  $ACB$  is equal likewise. Suppose it, for Example, to be of 57 Degrees, 25 Minutes: Then measure with the Hexapedes the Distance  $CB$ , which will be, v. gr. of 235 Feet. If a Triangle be made on Paper semblable to that, the Altitude  $BA$  will be found to be of 267 Feet, and a little more.

But



But this *Problem* is resolved, with a greater Accuracy, by the Table of the *Sines*: For if a Circle be described from the Point C, in the internal CB, the *Radius* CB will be the whole *Sine*; the Line CA, will be the *Secant*; and the Line, or Tower AB, will be the *Tangent* of the Angle ACB. Therefore if it be said, as the *whole Sine*, which in the Table is 10000000, is to the *Tangent* of the Angle ACB, 57 Deg. 25 Min. which is in the Tables 15646590; so is the Distance CB, which is found to be of 235 Feet to the Altitude or Height BA: This Altitude BA will be found by the Rule of Proportion to be of 367 Feet eight Inches.

*Note*, That as that Part of *Geometry* which regards the Solution of Triangles, or whereby their Sides are known by the Rules of Proportion, and expressed by Number, is called *Trigonometry*, I'll defer mentioning any Thing about it, till I come to the Letter T. where I design to write an entire Treatise of that Art, *Trigonometry*.

*Herodotus*, *Lib. 2.* and *Strabo*, *Lib. 17.* assert the *Egyptians* to be the first Inventors of *Geometry*; and the annual Inundations of the *Nile* to have been the Occasion; for that River bearing away all the Bounds and Landmarks of Men's Estates, and covering the whole Face of the Country, the People, say they, were obliged to distinguish their Lands, by the Consideration of their Figures and Quantity; and thus by Experience and Habit formed themselves a Method or Art which was the Origin of *Geometry*. A further Contemplation of the Draughts of Figures, or Fields thus laid down, and plotted in Proportion, might naturally enough lead them to the Discovery of some of their excellent and wonderful Properties; which Speculation continually improving, the Art became gradually improved, as it continues to do to this Day. *Josephus* however seems to attribute the Invention to the *Hebrews*; and others among the Antients make *Mercury* the Inventor.

The Province of *Geometry* is almost infinite: Few of our Ideas but may be represented to our Imagination by Lines, upon which they straight become of geometrical Consideration; it being *Geometry* alone that makes Comparisons, and finds the Relations of Lines.

Astronomy, Musick, Mechanicks, and in a Word, all the Sciences which consider Things susceptible of more and less, *i. e.* all the precise and accurate Sciences may be referred to *Geometry*. For all speculative Truths consisting only in the Relations of Things, and in the Relations between those Relations, they may be all referred to Lines. Consequences may be drawn from them; and these Consequences again being rendered sensible by Lines, they become permanent Objects, constantly exposed to a rigorous Attention and Examination: And thus we have infinite Opportunities, both of enquiring into their Certainty, and pursuing them further.

The Reason, for Instance, why we know so distinctly, and mark so precisely, the Concords call'd *Octave*, *Fifth*, *Fourth*, &c. is, that we have learn'd to express Sounds by Lines, *i. e.* by Chords accurately divided; and that we know that the Chord, which sounds *Octave*, is double of that which it makes *Octave* withal; that the fifth is in the sesquialterate Ratio, or as three to two; and so of the rest.

The Ear itself cannot judge of Sounds with such Precision; its Judgments are too faint, vague, and variable to form a Scheme. The finest, best-tun'd Ear, cannot distinguish many of the Differences of Sounds; whence many Musicians deny any such Differences, as making their Sense their Judge. Some, for Instance, admit no Difference between an *Octave* and three Ditones; and others, none between the greater and lesser Tone; the Comma, which is the real Difference, is insensible to them; and much more the Siesma, which is only half

the Comma. It is only by Reason, then, that we learn, that the Length of the Chord, which makes the Difference between certain Sounds, being divisible into several Parts, there may be a great Number of different Sounds contained therein, useful in Musick; which yet the Ear cannot distinguish: Whence it follows, that had it not been for *Arithmetick* and *Geometry*, we had had no such Thing as regular, fix'd Musick; and that we could only have succeeded in that Art by good Luck, or Force of Imagination, *i. e.* Musick would not have been any Science founded on incontestable Demonstrations: Tho' we allow the Tunes, composed by Force of Genius and Imagination, are usually more agreeable to the Ear, than those composed by Rules.

So in Mechanicks, the Heaviness of a Weight, and the Distance of the Center of that Weight from the Fulcrum, or Point it is sustained by, being susceptible of *plus* and *minus*, they may both be expressed by Lines; whence *Geometry* becomes applicable hereto; in Virtue whereof, infinite Discoveries have been made of the utmost Use in Life.

*Geometrical* Lines and Figures are not only proper to represent to the Imagination the Relations between Magnitudes, or between Things susceptible of more and less; as Spaces, Times, Weights, Motions, &c. but they may even represent Things, which the Mind can no otherwise conceive, *e. gr.* the Relations of incommensurable Magnitudes.

We do not however, pretend that all Subjects Men may have Occasion to enquire into, can be expressed by Lines. There are many not reducible to any such Rules: Thus the Knowledge of an infinitely powerful, infinitely just God, on whom all Things depend, and who would have all his Creatures execute his Orders, to become capable of being happy, is the Principle of all Morality, from which a thousand undeniable Consequences may be drawn; and yet neither the Principle, nor the Consequences, can be expressed by Lines, or Figures.

Indeed, the antient *Egyptians*, we read, used to express all their philosophical, and theological Notions, by *Geometrical* Lines. In their Researches into the Reason of Things, they observed that God and Nature affect Perpendiculars, Parallels, Circles, Triangles, Squares, and harmonical Proportions; which engaged the Priests, and Philosophers, to represent the divine and natural Operations by such Figures: In which they were followed by *Pythagoras*, *Plato*, &c. whence that Saying of *Boethius*, *Nullam Divinorum Scientiam arithmetice attingere posse*.—But it must be observed, that this Use of *Geometry*, among the Antients, was not strictly scientific, as among us, but rather symbolical: They did not argue, or reduce Things and Properties unknown from Lines; but represented, or delineated Things that were known. In Effect, they were not used as Means or Instruments of discovering, but Images or Characters, to preserve or communicate the Discoveries made.

The *Egyptians* (*Gale* observes) used *Geometrical* Figures, not only to express the Generations, Mutations, and Destructions of Bodies; but the Manner, Attributes, &c. of the Spirit of the Universe, who diffusing himself from the Center of his Unity, through infinite concentrick Circles, pervades all Bodies and fills all Spaces. But of all other Figures they most affected the Circle and Triangle; the first as being the most perfect, simple, capacious, &c. of all Figures: Whence *Hermes* borrowed it to represent the divine Nature; defining God to be an intellectual Circle or Sphere, whose Center is every where, and Circumference no where.

The antient *Geometry* was confined to very narrow Bounds, in Comparison of the modern: It only extended to right Lines, and Curves of the first Order, or conick Sections; whereas into the modern *Geometry* new Lines of infinitely more and higher Orders are introduced.



## G I L D I N G.

**G**ILDING, or GUILDING, is the Art or Act of spreading, or covering a Thing over with Gold, either in Leaf or Liquid.

There are several Methods of *Gilding* among us; the Principals of which are *Gilding by the Fire*, which is peculiar to Metals, *Gilding on an oily Size*, and *Gilding on a water Size*.

There are two Ways of *Gilding by the Fire*, viz. that with liquid Gold, and that with leaf Gold.

The first is performed with Gold amalgamated with Mercury, in the Proportion of about an Ounce of Mercury to a Dram of Gold.

In order to the Operation, *Gilders* chuse their Gold with as little Alloy as possible, such as Gold Ducats, &c. which they beat to reduce it to a pretty thin Plate, which they cut afterwards into small Pieces, that it may melt the sooner; which done, they throw it into a Crucible red-hot, and when they see it ready to melt the Quantity of Mercury proportioned to the Gold, stirring the Mixture gently about till the Gold be melted, and incorporated with the Mercury, which is discovered at a Smoke arising from the Crucible; which no sooner perceived but they cast the Matter into Water to wash and purify it; and thence into other Waters, repeating the Lotion in order to take away the Blackness. Then they dry it in a Linnen Cloth, and likewise to separate the Mercury not united therewith; for the Metal never takes more of the Mercury than is necessary to amalgamate itself with it.

*Note*, That before the Mercury be united with the Metal in the Crucible, it must be squeezed through a Piece of shammy Skin, to free it of its Impurities, which could be an Obstacle to a perfect Amalgamation; and that the Mixture must be taken off the Fire as soon as it begins to smoke, lest the Mercury should evaporate and leave the Operation imperfect.

To prepare the Metal for this Amalgama, they scrub it with a wire Brush, and wet it with Water, or Beer, continuing to rub and wet till all the Foulness which might hinder the close Union of the Metals be removed: Which done, to quicken the Work further, they rub a Mixture of Quicksilver and Aqua-fortis over it.

They proceed now to apply the Gold, in order to which they use a little Knife, or a Brush made of brass Wire for that Purpose; with which they spread or overlay the whole Work, as even as may be, being careful to miss no Part: Then giving the Work a gentle Heat before the Fire, with a hair Brush they dab and spread the Amalgama further and evener thereon.

Thus far advanced, the Metal is set over the Fire upon a Grate or in a sort of Cage, under which is a Pan of Coals, by which Means the Mercury is raised in Fumes, and leaves the Gold alone adhering to the Work: In Proportion as the Mercury evaporating, and flying off, discovers Places where Gold is wanting, they take Care to supply them, by adding new Pieces of Amalgama, with the Knife or Brush.

The Work is then rubbed over, or rather polished, first with a Brush, made of pretty big Wires, dipped in Urine; and afterwards, with one made of finer Wires, dipped in Urine likewise, to finish it, or put it in a Condition to be *beated*, or *belled*, i. e. to have its Colour and Lustre heighten'd, which is the last Part of the Process, and which the *Gilders* keep to themselves as a mighty Secret.

The Method given by *Parker*, is to dip the Work in a Decoction of Argal, Sulphur, Salt, and as much Water as will cover it, holding it therein till it has acquired the Colour that pleases; then dipping it in cold Water. I have seen a *Gilder* heighten the Colour of his Work with a Decoction of Cream of Tartar and Beer, into which he used to dip it, while the Decoction was boiling, till it had acquired a Colour that pleased him; which I know, by the Beauty of his Works, to be a very good Secret.

To have the *Gilding* more rich, and lasting, they sometimes quicken the Work over again with Quick-silver and Aqua-fortis, and gild it a second Time, after the same Manner; proceeding, if Occasion be, even to a third or fourth Time, till the Gold lies the Thickness of a Nail on the Metal.

To prepare the Metal for *Gilding* with gold Leaves, it must be first well scratched, or raked; then polished with a Polisher; and thus set to the Fire to *blue*, i. e. to heat, till it appear of a blue Colour: This done, the first Lay of Gold is put thereon, and lightly rubbed down with a Polisher; and thus exposed to a gentle Fire: They usually give it three such Lays, or four at most; each Lay consisting of a single Leaf for the common Works, and of two for the extraordinary ones; after each Lay they set it afresh to the Fire: After the last Lay the Gold is in a Condition to be burnished.

The Basis or Matter, whereon the Gold is applied in *Gilding in Oil*, or an *oily Size*, according to M. *Felibien*, is the Remains of Colours found settled to the Bottom of the Pots, wherein the Painters wash their Pencils. This Matter, which is very viscid, they first grind; then pass it through a Linnen Cloth; and thus lay it with a Pencil, on the Matter to be gilt, after having first washed it once or twice over with Size; and if it be Wood, with some white Paint.

This Method obtains in *France*; but the *English Gilders* in lieu thereof, generally make use of a Gold Size made of yellow Oker, grounded fine with Water, and laid to dry on a Chalk-stone; then ground up with a due Proportion of fat drying Oil, to give it the Body or Degree of Stiffness required. With this Size they wash over the Thing to be gilt, by means of a Brush or a large Pencil. And, when almost dry, but while yet unctuous enough to catch and retain the Gold, they spread their Gold Leaves thereon either whole or cut in Pieces. To take up and apply the Leaves, they make use of a Piece of fine, soft, well carded Cotton, or of a Pallet for the Purpose; or barely the Knife, wherewith the Leaves are cut, according to the Parts of the Work they are to gilt, or the Breadth of the Gold to be applied. In Proportion as the Gold is laid they press it down smooth with a Bunch of Cotton or a Hare's Foot, to make it stick, and, as it were, incorporate with the Ground: With the same Hare's Foot, or a Camel's Hair-pencil, they mend any Cracks that may happen therein, after the same Manner as will be hereafter shewn in *Water-gilding*.

*Note*, That this Sort of *Gilding* is chiefly used for Domes, and Roofs of Churches, Courts, Banqueting-Houses, &c. and for Figures of Plaster, Lead, &c. that are to stand exposed to the Weather.

*Water-Gilding* is not performed with less Apparatus; nor is it used so frequently, nor on such large Works as the former; wooden Works, and those of Stucco, are almost the only ones gilt in this Way; which besides must be sheltered from the Weather. The Size made use of for *Gilding* is to be made of Shreds, &c. of Parchment or Gloves boiled in Water to the Consistence of a Jelly.

If it be Wood that is to be gilt, they first give it a Wash of this Size boiling-hot; and when this is dry, another of Whiting mixed up with the same Size. For this Whiting some use Plaster of *Paris* well beaten and sifted; others *Spanish* White or Cerufs, &c. it is laid on with a stiff Brush, and oftener, or seldom repeated, according to the Nature of the Work: For Pieces of Sculpture seven or eight Lays suffice; for flat or smooth Works ten or twelve; in the latter Case they are applied by drawing the Brush or Pencil over the Work; in the former by dabbing it smartly on, that the Size may enter all the Dents of the Carving.

When the whole is dry, they moisten it with fair Water, and rub it over with several Pieces of coarse Linnen,



if it be a Flat; otherwise they beat it, or switch it, with several Slips of the same Linnen, tied to little Sticks, to make it follow; and enter all the Cavities and Depressures thereof.

The White thus finished, they proceed to yellow it; observing, that if it be a Piece of Sculpture in Relievo, they first touch up, and repair the several Parts which the white Ground may have disfigured, with little Iron Instruments; or Gravers, Chissels, Gauges, &c.

*Note*, That the yellow, which they use, is only common Oker, well ground and sifted; and thus mixed up with the Size used for the White, only weaker by one Half.

This yellow Colour is laid on hot, and in Works of Sculpture serves to supply the Place of Gold, which frequently cannot be carried into all the Cavities, and Dentings of Foliages and other Ornaments. Over this yellow they apply a Lay, which is to serve for the Ground whereon the Gold is to be immediately laid: It is usually composed of the *Armenian Bole*, Blood-stone, Black-lead, and a little Fat, to which some add Soap, and Oil of Olive; others burnt Bread, Bistre, Antimony, Tintglass, Butter, and Sugar-Candy. These Ingredients being all ground together with hot Size, they apply three Lays of the Composition upon the yellow, each after the other is dried; taking Care not to put any in the small Cavities of the Work, to hide the yellow. The Brush used in this Application, is to be soft; and when the Matter is well dried, they go over it with a stronger Brush to rub it down, and take off the little prominent Grains, and thus facilitate the Burnishing of the Gold.

*Note*, That *Gilders*, before they can proceed to *gild*, must have three Pencils; one to wet, another to touch up, and amend, and a third to flatten: There is also requir'd a Cushion to spread the Gold Leaves on, when taken out of the Book; a Knife to cut them; and a Hare's Foot, or Squirrel's Tail, fitted with a Handle; or else a Piece of Cotton, to take them up, direct, and apply them.

Fitted with these Tools, he begins with the wetting Pencils, with which he moistens the Layer, last laid on, with Water, that it may the better receive and retain the Gold: The Leaves are then laid on the Cushion, and taken up, if whole, with the Squirrel's Tail; if in Pieces, with the other Instrument, or even the Knife they are cut withal, and laid and spread gently on the Parts of the Work before moisten'd. When the Leaves happen to crack, or break in laying on, he makes up the Breaches with little Pieces of Leaf, taken up on the repairing Pencil; and with the same Pencil, or another somewhat bigger, they smooth the whole, pressing the Gold into the Dents, where it could not so well be carried with the Squirrel's Tail.

*Note*, That the Work thus far *gilt*, when dry, remains either to be burnish'd or matted.

To burnish it, is to smooth, and polish it with a Burnisher, which is usually a Dog or Wolf's Tooth, or a Blood-stone, an Agate, or a Pebble, fitted in a Handle for the Purpose.

To mat it, is to give it a light Lick in the Places not burnished, with a Pencil dip't in Size, wherein a little Vermillion, sometimes, has been mix'd. This helps to preserve and prevent its flawing, when handled.

The last Thing is to apply a Vermeil, or Lacquer,

in all the little Lines and Cavities; and to stop and amend any little Faults with Shell Gold.

*Note*, That the Composition here called *Vermeil*, is made of Gum Gutta, Vermillion, and a little of some ruddy brown Colour, ground together, with *Venice Varnish*, and Oil of Turpentine. Some *Gilders*, in lieu hereof, content themselves with fine Lacca, or Dragon's Blood, with Gum Water.

Sometimes instead of burnishing the Gold, they burnish the Ground, or Composition laid on last before it; and content themselves afterwards to wash the Part over with Size. This Method is chiefly practis'd for the Hands, Face, and other Nudities in Relievo; which by this Means, do not appear so very brilliant as the Parts burnish'd; tho' much more so, than the Parts perfectly flat or matted.

*Note*, That to *gild* a Work, and yet preserve white Grounds, they apply a Layer of *Spanish White*, mixed with a weak Fish Glue, on all the Parts of the Ground whereon the yellow, or the Layer next under the Gold, might run.

The Art of *Gilding* was not unknown among the Antients, though it never arose among them at the Perfection to which the Moderns have carried it. *Pliny* assures us, that the first *Gilding* seen at Rome, was after the Destruction of Carthage, under the Censorship of *Lucius Mummius*, when they began to *gild* the Ceilings of their Temples, and Palaces; the Capitol being the first Place on which this Enrichment was bestow'd. But he adds, that Luxury advanced on them so hastily, that in a little Time you might see all, even private and poor Persons, *gild* the very Walls, Vaults, &c. of their Houses.

We need not doubt but they had the same Method with us of beating Gold, and reducing it into Leaves; though it should seem they did not carry it to the same Height; if it be true, which *Pliny* relates, that they only made seven hundred and fifty Leaves, four fingers square, of a whole Ounce. Indeed he adds, that they could make more; that the thickest were called *Bractea Prænestina*, by Reason of a Statue of the Goddess Fortune, at *Præneste*, gilt with such Leaves; and that the thinner Sort were called *Bractea Quæstoria*.

The modern *Gilders* do also make use of Gold Leaves of divers Thickness; but there are some so fine, that a Thousand don't weigh above four or five Drachms. The thickest are used for *Gilding* on Iron, and other Metals; and the thinnest on Wood; but we have another Advantage over the Antients, in the Manner of using and applying the Gold. The Secret of Painting in Oil, discover'd of late Ages, furnishes us with Means of *Gilding* Works, that shall endure all the Injuries of Time and Weather, which to the Antients was impracticable. They had no Way to lay the Gold on Bodies that would not endure the Fire, but with Whites of Eggs, or Size; neither of which will endure the Water: So that they could only *gild* such Places as were shelter'd from the Moisture of the Weather.

The *Greeks* called the Composition on which they applied their *Gilding* on Wood, *Leucophæum*, or *Leucophorum*, which is described as a Sort of glutinous, compound Earth, serving, in all Probability, to make the Gold stick, and bear polishing; but the Particulars of this Earth, its Colour, Ingredients, &c. the Antiquaries, and Naturalists, are not agreed upon.



## GLASS-GRINDING.

**G**LASS-GRINDING, as I take it in this Place, is the Method of rubbing, or wearing off the irregular, and otherwise redundant Parts of the Surface of a Piece of Glass, and reducing it to the destin'd Figure, whether that be flat, concave, or the like.

This Art is more particularly appropriated to grinding of *Optick-Glasses*.

*Optick-Glasses*, are ground either *Concave*, or *Convex*, so as either to collect or disperse the Rays of Light; by Means whereof Vision is improved, and the Eye strengthen'd, preserv'd, &c.

For *Convex-Glasses*, the first Thing to be done is to provide a Dish or Bason, within whose Cavity, the Glass is to be form'd. In order to this, they take a Piece of Brass, Copper, Iron, or Wood, and form it into a Segment of a Circle, having the Radius of the Bason, or Dish intended. This done, a Bason is forged by a Smith, either of Iron or Copper, having its Cavity exactly fitting, or corresponding to the Segment above-mention'd.

If the Artist chuses rather to have the Bason cast, he must take Clay well dried, pulverize and sift it; mix it up with Water, and then strain, or filter it; with this he works up Horse-Dung, and Hair shred small, till the Mass be sufficiently tough; to which, on Occasion, may be added Charcoal-Dust, or Brick-Dust, well sifted.

Two coarse Moulds are then prepar'd of a gritty Stone, the one Convex, the other Concave, which are to be ground on one another with wet Sand between, till such a Time as the one perfectly fits the other; by this Means a perfect spherical Figure is acquir'd. The Mass prepar'd before, is now to be extended on the Table with a wooden Roller, till it be of a Thickness proper for the Glass; and then being strewed with Brick-Dust to prevent its sticking, it is laid over the convex Mould, and so gets the Figure of the Glass. When this is dry, it is cover'd with another Lay of the same Mass, which once dried, both Covers, or Segments of the hollow Sphere, made of Clay, are taken off. The Innermost of the two being laid aside, the Stone Mould is anointed with a Pigment prepar'd of Chalk and Milk, and the outer Cover again put over it, &c.

But if the Bason forg'd by the Smith is to be used, when it is thus roughly form'd, it must be finished in the Pewterer's Lath, or on a Stone Mould, fixed to an Iron Axis, with a Pinion moveable by a Wheel, and that by a Winch or Handle.

The Bason being ground on the Mould, till it exactly fits in all Parts, is taken off, and cemented to a wooden Block (loaden if needs be with Lead) strew'd over with fine sifted Sand, and thus ground over again on the Mould, till all the Furrows or Scratches be quite taken away.

Lastly, large Pieces of Glass are ground in a Bason, with fine Sand between; till such Time as its Surface being well smoothed, there is no longer an Opposition to the Motion.

*Note*, That the Dish is known to be perfectly finished, when a Hair being stretched over it, its Shadow projected on the Cavity, particularly in a *Camera obscura*, does not appear distorted.

The Bason finished, the Artist proceeds to chuse Glasses for the Purpose; which he does by laying them on clean Paper, and observing what Colours are projected thereon; for the same are the Colours of the Glasses. Always setting aside those of the darker Colours, and chusing the brighter; but as the whitest and brightest have usually Veins, and besides, in Tract of Time, by the Humidity of the Air are apt to rust, and lose their Polish; for this Reason *Huygens* recommends those a little yellowish, reddish, or greenish; *Hevelius* the blueish.

*Note*, That a Glass is found to be free from Bubbles, Sands, Veins, Knots, and Spires, by holding it to

the Sun, and receiving the Rays through it on a white Paper; for the Flaws abovementioned will each project a Shadow thereon.

*Note*, also, That if instead of lenticular, or at least spherical Glasses, we make use of Plate Glass; it must be divided and cut with a Diamond into Squares; and if it be too thick to break otherwise, we may do it by laying it on a Table covered with a Cloth, in such manner, as that the Side, or Part to be severed, hang over the Edge; for being struck with an Iron Instrument in this Situation, it easily breaks in the Direction of the Line drawn by the Diamond.

Having thus got a square Piece of Glass, we must describe two concentrick Circles thereon, with a Pair of Compasses, one of whose Legs carries a Diamond; the Diameter of the inner Circle to be equal to the Breadth of the intended *Lens*, and that of the outer somewhat more, and break off the Corners as above directed; taking off the lesser Inequalities on a grinding Stone, or the like. We examine, next, whether the Piece of Glass be every where equally thick; if it be not, we must reduce it to such Equality, by *grinding* it on an Iron Plate with Sand and Water.

Lastly, we glue, or cement the Glass, thus prepared, to a wooden Handle, with a Cement made of Pitch, and a fourth Part of Rosin; or one Part of Wax, and eleven of Colophony; taking Care that the Base, or Bottom of the Handle, be equal to the Glass; and that the Center of the Glass and Handle meet together. Smaller *Lens's*, as those used for Microscopes, are fixed on with Sealing Wax.

All Things thus prepared, there remains nothing but to *grind* the Glass, and bring it to the Convexity required; which is performed by smearing over the Dish equally with fine sifted Sand moisten'd with Water; then taking the Handle with the Glass thereon, working it over, sometimes this Way, and sometimes that, to prevent the Form of the Bason from being disturbed; never leaning too hard thereon.

When the Glass has got the Figure of the Bason, we must clean it well of all the Sand, and Filth adhering; and sprinkle the Bason over with Emery moistened with Water; *grinding* the Glass thereon, till all the Roughness, and Inequalities, are taken away. After this, the Sand used in Hour-Glasses may be of Service, applied, and used as before; remembering to take out the Sand when too much worn, and substitute new in its Stead. Some, in lieu hereof, chuse several Sorts of Emery, each finer than the other, or even the Powder of Flints calcined and pounded.

Lastly, the same Glass must be ground in another Bason or Dish, which is a Segment of a lesser Sphere, making use of the like Sand as before; till it has got a pretty high Rim or Margin all around.

*Note*, That in regard the Pressure is not here determined accurately enough upon the Middle of the Glass, by the mere Guidance of the Hand, some have chose to make use of the following Machine, especially for *grinding* Object-Glasses. They fix the Dish on an horizontal Table; and let the Aperture of the Machine be over its Center, through which passes an Iron Arm five or six Inches long, fastened to a Staff; leaving the other End of the Staff to be fitted into a Hole cut in the Dish, and fastened therein. Now to grind the Glass instead of the Dish, they take hold of the said Staff and work with Sand, &c. as before.

*Note*, also, That *Huygens* tells us, that he first used coarse Emery, then a fine Powder of the same, which would be fifty Seconds in sinking to the Bottom of a Vessel of Water, putting in fresh every half, or quarter of an Hour. Sometimes too, he used Emery of fifty Seconds for  $\frac{1}{2}$  of an Hour; then Emery of 400 Seconds for  $\frac{1}{4}$  of an Hour; and lastly, Emery of 45 Minutes, for  $\frac{1}{4}$  of an Hour.

The



The Manner of grinding *Concave Lens's*, is to cement a little Piece of Copper to the End of the Arbor of a Lath, and turning it till it forms a Dish or Bason, of the Diameter of the Lens required; then a Piece of clear Glas is cemented on one of its flat Sides, to the End of a little Maudrel with black *Spanish Wax*; and thus grinding on the Side not cemented on a Grindstone with Water till it have nearly acquired a concave Figure. It is finished in the Lath, by turning it in the Bason, with fine wet Sand, or Grit-stone; which Grit must be often repeated fresh, till the Lens appear very round. When it is come to that Point they cease to take any fresh Stone, but continue to turn it in the Bason, till the Remains of the Sand are become so fine as to have polished it; which is perceived when upon wiping it, the Image of the Window of the Place is seen painted on its Surface; if it does not, it is wetted in Water without any Sand, and turned till it have got a Polish: The Bason is then covered within-side with two or three Folds of Linnen, and the Polish of both the *Convex* and *Concave Glafs*, finished with Putty or Tripoly of Venice steeped in Water.

They are known to be perfectly polished, when, viewing them with a Magnifier, there appear no Scratches of the Sand. The Cement is then broke off, and the polished Side cemented, to work and *grind* the other, as before, till the Edges of the *Lens* become sharp, and is perfectly polished on either Side. When finished, they are washed in Spirit of Wine, to take off all Remains of the Wax.

*Note*, That the principal among *Optick Glasses*, are *Telescopes*, *Microscopes*, *Spectacles*, *Reading-Glasses*, *Magick Lanthorns*, &c. whose Glasses are all ground in the Manner abovementioned.

*Glas-grinding*, is also appropriated to the Act of smoothing, or polishing the Surface of *Glas* for *Looking Glasses*.

In order to this, the Plate of *Glas* is laid horizontal on a Stone, in Manner of a Table; and to secure it the better, plaister'd down with Mortar, or Stucco, that the Effort of the Workman, or of the Machine used therein, may not shake, or displace it: To sustain it, there is a strong wooden Frame, that surrounds it an Inch or two higher than the *Glas*. The Bottom, or Base of the *grinding Engine*, is another tough *Glas*, about half the Dimensions of the former: On this is a wooden Plank, cemented thereto; and upon this are proper Weights applied to promote the Triture; the Plank, or Table, being fastened to a Wheel, which gives it Motion. This Wheel, which is at least five or six Inches Diameter, is made of a very hard, but light Wood, and is wrought by two Workmen, placed against each other, who push and pull it alternately; and sometimes, when the Work requires it, turn it round: By such Means a constant mutual Attrition is produced between the two *Glasses*, which is favoured by Water, and Sand of several Kinds

bestowed between; Sand still finer and finer being applied, as the *Grinding* is more advanced; at last Emery is used: We need not add, that as the upper, or incumbent *Glas*, polishes and grows smoother, it must be shifted from Time to Time, and other put in its Place.

*Note*, That only the largest size *Glasses* are thus ground with a Mill; for the middling, and smaller Sorts are wrought by the Hand, to which End there are four wooden Handles at the four Corners of the upper Stone, or Carriage, for the Workmen to take hold of, and give it Motion.

The *Plate* being thus fitted for *Polishing*, a wooden Parallelepiped, lined with *Tripoli Earth*, or burnt Tin, temper'd with Water, is laid on the Plate, and worked to and again, till the *Glas* have got a perfect Politure.

*Note*, That it is found extremely difficult to bring the *Glas* to an exact Plainness. *Hevelius* judges more Art required to bring *Glas* to a perfect Plane, than to a Sphere. For polishing large Plates of *Glas*, they have a Machine for the Purpose.

The Plate being polished, if it be for a *Looking-Glas*, thin blotting Paper is spread on a Table, and sprinkled with fine Chalk; this done, over the Paper is laid a thin Lamina, or Leaf of Tin, on which is poured Mercury, which is to be equally distributed over the Leaf with a Hare's Foot or Cotton; over the Leaf is laid a clean Paper, and over that the *Glas* Plate. With the left Hand the Plate is pressed down, and with the Right the Paper is gently drawn out; which done the Plate is covered with a thicker Paper, and loaden with a greater Weight, that the superfluous Mercury may be driven out, and the Tin adhere more closely to the *Glas*. When it is dried the Weight is removed, and the *Looking-Glas* is compleat.

*Note*, That some add an Ounce of Mercury to half an Ounce of Marcasite melted by the Fire; and lest the Mercury evaporates in Smoak, pour it into cold Water, and when cold, squeeze it through a Cloth or Leather. Some also add a Quarter of an Ounce of Lead and Tin to the Marcasite, that the *Glas* may dry the sooner.

*Note*, also, That in the philosophical Transactions, N<sup>o</sup> 245, we have a Method of *foliating Globe Looking-Glasses*, communicated by Sir R. Southwell. The Mixture is of Quicksilver, and Marcasite of Silver, of each three Ounces; and Tin and Lead, of each half an Ounce; to the two last thrown on the Marcasite, and afterwards the Quicksilver; stir them well together over the Fire; but they must be taken off, and be towards cooling before the Quicksilver be put to them. When you use it, the *Glas* should be well heated and very dry; but it will do also when it is cold, though best when the *Glas* is heated.

*The End of the FIRST VOLUME.*





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